



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBST1007-11
Job Sheet 171041



Part No: RBST1007-11

Job Qty: 1 ea

Part Name: Primary Seat



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/26/18

Job Tracking No:

Due Date: 1/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: RBST1000 REV.7 IPP REV:A 18.01.25 NEW ISSUE JFC VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		1/30/18	0.00	0.00	Start Up Machining-4		18-2-20
110	CNC Lathe	1 pcs		1/31/18	0.00	0.25	MORI SL-154		
120	QC	1 pcs		1/31/18	0.00	0.00	QC2		
130	QC	1 pcs		1/31/18	0.00	0.00	QC8		18-02-26
150	Outsource	1 pcs		1/31/18	0.00	0.00	Outsource12		AT 18/03/19
160	Packaging	1 pcs		1/31/18	0.00	0.00	Packaging2		AT 18/03/19
170	QC	1 pcs		1/31/18	0.00	0.00	QC6		GA 18-03-19
180	Packaging	1 pcs		1/31/18	0.00	0.00	Packaging3		GA 18-03-19
210	QC21-SA	1 Ea		1/31/18	0.00	0.00			GA 18-03-19

Part Op 110 - 1-Machine as per FOLIO FB757. FOLIO REV:

DWG REV:

2-Deburr 3-Engrave P/N

Descriptions: And / or S/N number as required Using Marktronic engraver as per DWG.

150 - Issue P/O to Groupe Altech; PO D35186 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required

GA 18-03-19

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R1.375	MT-4140 QT-R1.375	.1000 ft (.1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140QT-R1.375	0	0	0

Part Specifications



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

It be found.

Container No: S043843



Part: RBST1007-11

Job No: 171041

Serial No/Batch: S043843

Revision: RBST1000

Inspector:

Plex 1/26/18 8:47 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval 	
Description Work Order Deviation		Disposition			
				Completed By 	
				Lead hand / Supervisor Approval Verification 	
				QC / QA Coordinator Approval 	

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____ _____ _____					
Misidentified ☐	Past Due ☐						

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

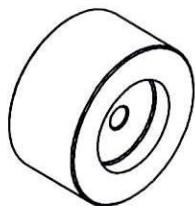
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By 		
							Lead hand / Supervisor Approval Verification 		
							QC / QA Coordinator Approval 		

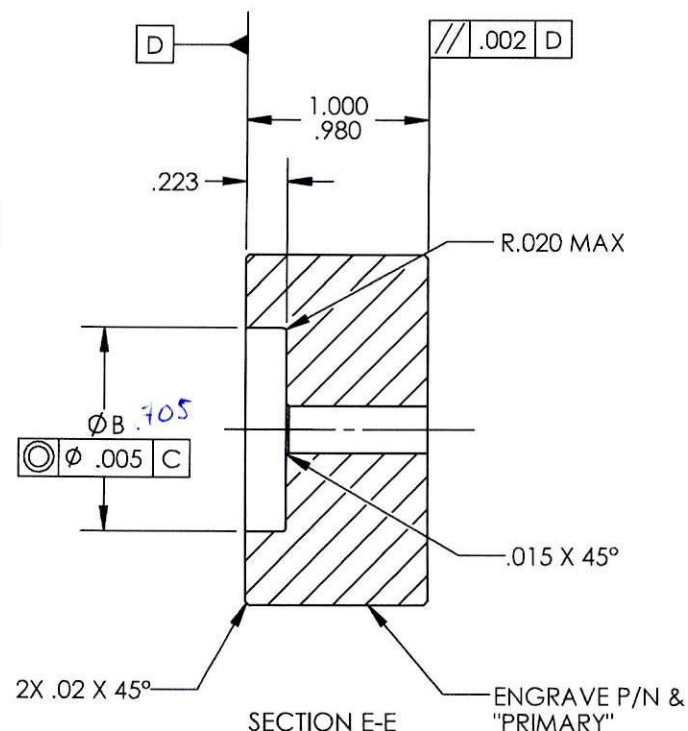
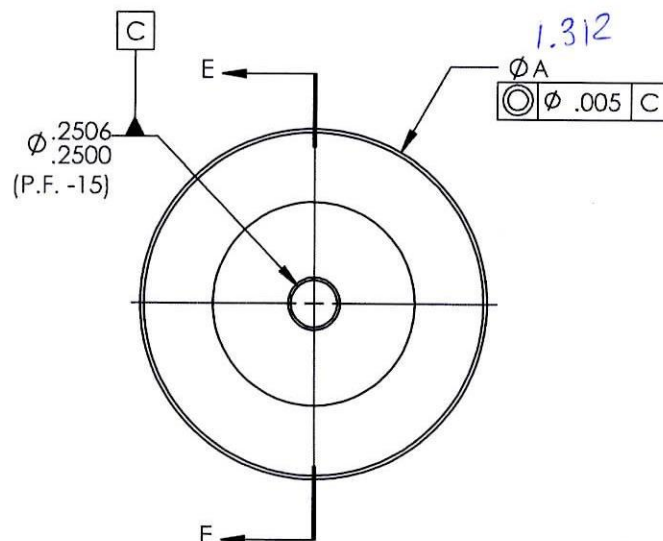
Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : 			
Misidentified	☐	Past Due	☐				

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
7	15-0033	-11 CH'D MATL FROM 4140 Q&T TO 4140/4142. ADDED HEAT TREAD RC 28-34, ADDED FINISH SPEC QMSI-6.2.2. B.O. REV D. CH'D DIM WAS REAM Ø.249 P.F. -1.5 IS LIMITS Ø.2500-.2506. IMPROVED GD&T.	2/17/2015	DPD	SM



TOOL NUMBER	ØA +.000 -.030	ØB +.000 -.005
RBST1000	1.062	.470
RBST1001		
RBST1002		
RBST1003		.505
RBST1004		
RBST1005		
RBST1006	1.312	.630
RBST1007		.705
RBST1008		
RBST1009	1.500	.755
RBST1010		
RBST1011		
RBST1012		.885
RBST1013		
RBST1014		
RBST1015	1.875	1.090
RBST1016		1.140
RBST1017		1.220
RBST1018	2.062	1.156
RBST1019		1.385
RBST1020	2.437	1.660



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 171041 MWS
182226

NOTE:
BREAK ALL SHARP EDGES .015 - .030.

			
TITLE RBST1000 THRU 1020 DRILL PRESS TRI-ROLLER SWAGING TOOL			
DWG NO. SEE TABLE-11			REV 7
MAT'L 4140/4142		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT RC 28-34		.XXX $\pm$.005 FRACTIONS $\pm$ 1/8	
FINISH BLACK OXIDE		.XX $\pm$.01 ANGLES $\pm$ 5°	
SPEC QMSI-6.2.2, B.O. REV D		.X $\pm$.1 SURFACES = 125/✓	
DRAWN BY: PERRITT		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED: MACKOVJAK		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR: ANDERSON		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: LINDSAY		USED ON MODEL	
APPROVED: MACKOVJAK		SEE TABLE	
SCALE 1:1	DATE 1/4/2008	SHEET 7 OF 9	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO039186

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
13	171041	RBST1007-11	required Primary Seat -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	3/16/18	4 pcs	0 pcs	4 pcs	\$1.15/pcs	\$4.60
Grand Total:										\$393.33

DAS
36
9-88

Order Notes										
Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A017 raw material identification (as applicable) A022 Apical Processing A024 process certifications A026 certification of material conformance A041 quality management system A042 dart notification by supplier A043 retention of quality documents A048 counterfeit parts avoidance, detection, mitigation and disposition program A049 supplier awareness Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.										

CD
JLB

Plex 3/7/18 11:07 AM dart.baker.diane

Certificat de Conformité / Certificate of Compliance



007318-1



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

007318- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax: .

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
16-Mar-2018		Celine Schreindorfer		PO039186				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
2	RBE2-10-1-01 Rev.	RBE2-10-1-01 01 - BLACK OXIDE ON SST MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4	BLACK-OXIDE CH	6	6	0	0	0
3	RBE350A93-3303-02-1 Rev.	RBE350A93-3303-02-1 01 - BLACK OXIDE FINISH M MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	6	6	0	0	0
4	RBE350A93-3303-02-3 Rev.	RBE350A93-3303-02-3 01 - BLACK OXIDE FINISH ON SST MIL-C-13942C, CLASS 1	BLACK-OXIDE CH	6	6	0	0	0
5	RBE350A93-3317-20 Rev.	RBE350A93-3317-20 01 - BLACK OXIDE FINISH ON SST MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	6	6	0	0	0
6	RB412WA-CR&O-3-62-2A-1-2 Rev.	RB412WA-CR&O-3-62-2A-1-2 ASTM B633 TYPE 1 SC2 01 - ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT]	ZINC CH	✓ 4	4	0	0	0
7	RBW6405G02331-3G-05 Rev.	RBW6405G02331-3G-05 ON SST MIL-C-13924C, CLASS 1 01 - ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT]	ZINC CH	✓ 2	2	0	0	0
8	RBW6405G02331-3G-07 Rev.	RBW6405G02331-3G-07 ASTM B633 TYPE 1 SC2 01 - ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT]	ZINC CH	✓ 9	9	0	0	0
10	RBST1007-13 Rev.	RBST1007-13 01 - BLACK OXIDE ON SST MIL-C-13924C CLASS 1	BLACK-OXIDE CH	4	4	0	0	0
11	RBT18603-01 Rev.	RBT18603-01 01 - BLACK OXIDE ON SST MIL-DTL-13924C CLASS 1	BLACK-OXIDE CH	5	5	0	0	0
12	RBT18603-07 Rev.	RBT18603-07 01 - BLACK OXIDE ON SST MIL-DTL-13924C CLASS 1	BLACK-OXIDE CH	4	4	0	0	0
13	RBST1007-11 Rev.	RBST1007-11 01 - BLACK OXIDE ON SST MIL-C-13924C CLASS 1	BLACK-OXIDE CH	4	4	0	0	0

9. RBE350A94-3700-C-0

DAS
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DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Notes Additionnelles / Additional Notes

Réçu par
Received By

Page 2 of 2